

# Work Order ID 50327

July 14, 2009 12:11:17 PM



Page 1

Item ID: D2607

Accept



Setup Start



Revision ID: A1

Stop



Item Name: Bracket, 206 Console

Start Date: 7/15/09 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 09-07-15 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |                |              |              |               |               |                  |                |
| D2607                          | Rev A1                   |                      |                |              |              |               |               |                  |                |

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2607 ☐ Dwg Rev: A1 ☐ Prog Rev: A1 ☐ 2-  
Deburr if necessary

1B 9-8-13

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1B 9-8-13

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) 8/6/13  
8/6/13



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |



**NOTE:** Date & initial all entries




# Work Order ID 50327

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|                |                      |            |   |   |               |   |
|----------------|----------------------|------------|---|---|---------------|---|
| Item ID:       | D2607                | Accept     |  | Setup   | Start         |  |
| Revision ID:   | A1                   |            |   |   | Stop          |  |
| Item Name:     | Bracket, 206 Console |            |   |   |               |   |
| Start Date:    | 7/15/09              | Start Qty: | 6.00  |  | Cust Item ID: |   |
| Required Date: | 7/15/09              | Req'd Qty: | 6.00  |  | Customer:     |   |
| Reference:     |                      |            |   |   |               |   |

|            |               |       |            |       |     |       |   |
|------------|---------------|-------|------------|-------|-----|-------|---|
| Approvals: | Process Plan: | Date: | Tooling:   | Date: | Run | Start |  |
|            | QC:           | Date: | SPC (Y/N): | Date: |     | Stop  |  |

| Sequence ID/<br>Work Center ID   | Operation<br>Description                      | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130<br><br>Brake NC     | NC BRAKE                                      | 0.00                 |                |              |              | 16            | <del>16</del> |                  | (P12) →        |
| Brake NC   | Memo<br>Deburr Form as per Dwg D2607          | 0.00                 |                | SB           | 09/08/18     |               |               |                  |                |
| 140<br><br>QC          | QC5- Inspect part completeness to step on W/O | 0.00                 |                | ⇒            | S 08/08/18   | (16)          | 16            |                  |                |
| QC   | Memo  | 0.00                 |                |              |              |               |               |                  |                |
| Quality Control  |   |                      |                |              |              |               |               |                  |                |
| 150<br><br>HandFinish | Chemical Conversion Coat per QSI005 4.1       | 0.00                 |                | ⇒            | Self         | 09-08-18      | (16)          | 16               |                |
| Hand Finishing   | Memo  | 0.00                 |                |              |              |               |               |                  |                |

⇒ inspect chemical coat  
QC3

⇒ S 08/08/18

(16) 16

| W/O: 50327 |      | WORK ORDER CHANGES  |    |          |     |                                     |                          |
|------------|------|---|----|----------|-----|-------------------------------------|--------------------------|
| DATE       | STEP | PROCEDURE CHANGE  | By | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 9/6/19     |      | Perment change<br>ADD step to inspect chemical cost "QC3" | MA | 09/08/20 |     |                                     | 09/02/19                 |
|            |      |   |    |          |     |                                     |                          |

Part No: D2607 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Work Order ID 50327

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|                |                      |            |      |       |               |  |
|----------------|----------------------|------------|------|-------|---------------|--|
| Item ID:       | D2607                | Accept     |      | Setup | Start         |  |
| Revision ID:   | A1                   |            |      |       | Stop          |  |
| Item Name:     | Bracket, 206 Console |            |      |       |               |  |
| Start Date:    | 7/15/09              | Start Qty: | 6.00 |       | Cust Item ID: |  |
| Required Date: | 7/15/09              | Req'd Qty: | 6.00 |       | Customer:     |  |
| Reference:     |                      |            |      |       |               |  |

|            |               |       |            |       |     |       |  |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling:   | Date: | Run | Start |  |
|            | QC:           | Date: | SPC (Y/N): | Date: |     | Stop  |  |

| Sequence ID/<br>Work Center ID | Operation<br>Description                        | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 160<br>                        | Identify as per dwg & Stock Location: <u>38</u> | 0.00                 |                |              |              |               |               |                  |                |
| Packaging                      | Memo  | 0.00                 |                |              |              |               |               |                  |                |
| Packaging                      |   |                      |                |              |              |               |               |                  |                |
| 170<br>                        | QC21- Final Inspection - Work Order Release     | 0.00                 |                |              |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |                |              |              |               |               |                  |                |
| Quality Control                |   |                      |                |              |              |               |               |                  |                |

9/8/19

09/08/20

MF 09-08-20

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

July 14, 2009 12:11:16 PM

Work Order ID: 50327



Parent Item: D2607RevA1



Parent Item Name: Bracket, 206 Console

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M2024T3S.040                    |                        | Purchased     | No          | -                   |                  | 100             | sf                 | 77.9100        | 0.7895                   | 16            |                |        |



2024-T3 .040 sheet



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| MAT              | 77.91          |                 |
| 110337           | 6.4            |                 |
| 111381           | 4              |                 |
| 111786           | 67.51          |                 |

111786

18 9-8-13

16

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



|   |  |                     |        |
|---|--|---------------------|--------|
| <b>DART AEROSPACE LTD</b>                   |  | <b>Work Order:</b>  | 50327. |
| <b>Description:</b> Console Bracket         |  | <b>Part Number:</b> | D2607  |
| <b>Inspection Dwg:</b> D2607 <b>Rev:</b> A1 |  | <b>Page 1 of 1</b>  |        |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.674             | +/-0.010      | 1.676            | ✓      |        |                      |          |
| R0.250            | +/-0.010      | .250             | ✓      |        |                      |          |
| 0.220             | +/-0.005      | .220             | ✓      |        |                      |          |
| R0.156            | +/-0.010      | .156             | ✗      |        |                      |          |
| 8.710             | +/-0.010      | 8.713            | ✓      |        |                      |          |
| 1.891             | +/-0.010      | 1.893            | ✓      |        |                      |          |
| 1.454             | +/-0.005      | 1.455            | ✗      |        |                      |          |
| 0.200             | +/-0.005      | .200             | ✓      |        |                      |          |
| 8.930             | +/-0.010      | 8.931            | ✗      |        |                      |          |
| Ø0.098            | +0.005/-0.000 | .099             | ✓      |        |                      |          |
| 0.040             | +/-0.005      | .042             | ✓      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|   |   |  |            |
|---|---|--|------------|
| <b>Measured by:</b> IB<br><b>Date:</b> 8-9-13 | <b>Audited by:</b> S<br><b>Date:</b> 09/09/13 | <b>Prototype Approval:</b><br><b>Date:</b> N/A | N/A<br>N/A |
|---|---|--|------------|

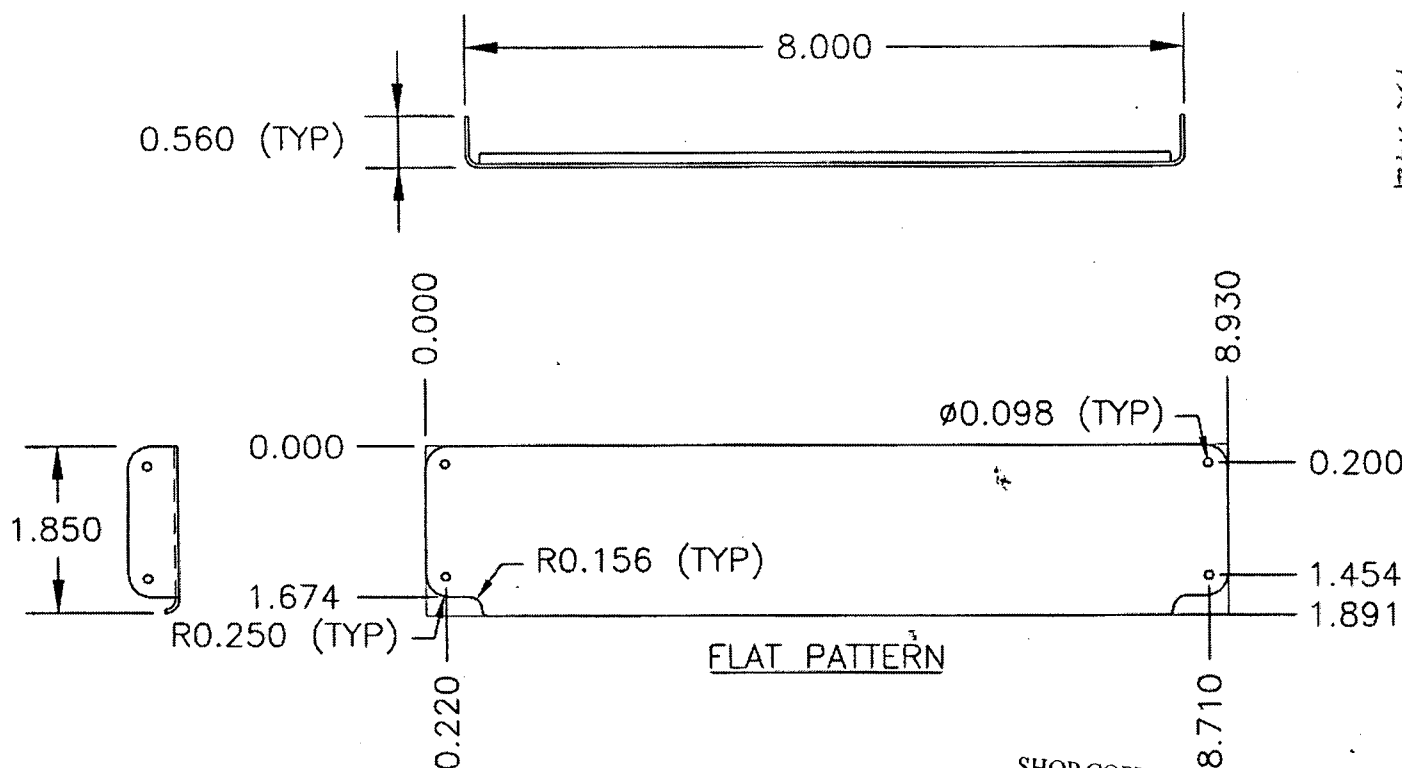
  

| Rev | Date     | Change    | Revised by | Approved           |
|-----|----------|-----------|------------|--------------------|
| A   | 05.02.17 | New Issue | KJ/JLM     | <i>[Signature]</i> |

QA COPY ISSUED

|          |                 |  |
|----------|-----------------|--|
| DESIGN   | UNKNOWN         | DARI AEROSPACE LTD                     |
| CHECKED  | APPROVED        | VICTORIA INTERNATIONAL AIRPORT, CANADA |
| DATE     | TITLE           | REV. A                                 |
| 97.10.23 | CONSOLE BRACKET | SHEET 1 OF 1                           |
| A        | 97.10.23        | D2607 WAS D206-547-9                   |
| A1       | 02.06.04        | ADD FINISH                             |

97.11.04 KE  
TSR 4421



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50327

MF 09-07-15

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK  
PROFILE CONTROLLED BY FOLIO H2607  
BEND RADIUS 0.093

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 